

Date: Tuesday, 12/5/2006 7:50:34 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 STEP ASSEMBLY
Job Number	: 29738		
Estimate Number	: 11769	Part Number	: D206628032
P.O. Number	: <i>NA</i>	Drawing Number	: N/A
This Issue	: 12/5/2006 S.O. No. : <i>N/A</i>	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Material	: <i>NA</i>
Previous Run	: 29709	Due Date	: 1/15/2007
Written By	: <i>[Signature]</i>	Qty:	3 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-032 CHG 002

KS 061211 (3)

2.0	29738A	206L /407 STEP ASSY, RH
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Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, RH

D2724-042 B *29738A*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27313	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓	4	D2731-3	Mounting Lug	<i>B9442-</i>
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5.0	D2856400	Abrasion Strip
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Comment: Qty.: 0.5460 f(s)/Unit Total: 1.6380 f(s)

Pick:

Qty Part # Description Batch

✓	2	D2856-400	6.25" Abrasion Strip	<i>B28258-</i>
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 29738

Part Number: D206628032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394041

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 4 D3394-041 LUG ASS,Y B25407

7.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 4 AN4-15A Bolt M102039

8.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

* ✓ 4 AN4-11A Bolt M5342

9.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 4 AN4-12A Bolt M4910 8X - M607 4X

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 12 AN960JD416 Washer M102339

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 12 MS21042L4 Nut (or MS21042-4) M19185

12/4/11 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ED Date: 06/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:50:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 29738

Part Number: D206628032

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 06/12/12 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-032

Location: _____

PPP Rev: D

PD 6/14/13 (3)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

PD 06/12/13

Job Completion



U 06.12.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

106.678.032

Dart Aerospace Ltd.

Date: Tuesday, 12/5/2006 7:50:49 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, RH
 Job Number : 29738A
 Estimate Number : 11703
 P.O. Number : *N/A*
 This Issue : 12/5/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 29713A
 Written By :
 Checked & Approved By : *061205*
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Part Number : D2724042
 Drawing Number : D2724 REVC
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 1/15/2007 Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>B28215</i>

Check Material for any Dents or Defects

12/06/12/11

(3)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

12/06/12/11

(3)

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>B27281</i>

12/06/12/12

(3)

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<i>B29354</i>

12/06/12/12

(3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:50:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 29738A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description
2 D3458-3 Plate

Batch

B27355

A 06/12/12 (3)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

AT888

Weld end cap and lugs as per Dwg D2724 using Jig DT *8898* followed by Jig

DT (One End Only)

A/R AL ROD Batch: *M100237*

Grind end cap welds flush

A 06/12/12 (3)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06-12-12 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06-12-12 (3)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.a / y / 06/12/12 (3)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A 06/12/13 (3)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

A 06/12/13 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:50:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 29738A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M100237

Grind end plate flush.

ADoc/12/13 (3)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06-12-13 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06-12-13 (3)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FC 06 12 13 (3)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06-12-13 (3)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06/12/13 (3)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

FC 06-12-13 (3)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06/12/13 (3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A FC 9/12/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 17 Date: 06/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:50:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 29738A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



3

Comment: FINAL INSPECTION/W/O RELEASE

26/12/13

Job Completion



U 26-12-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

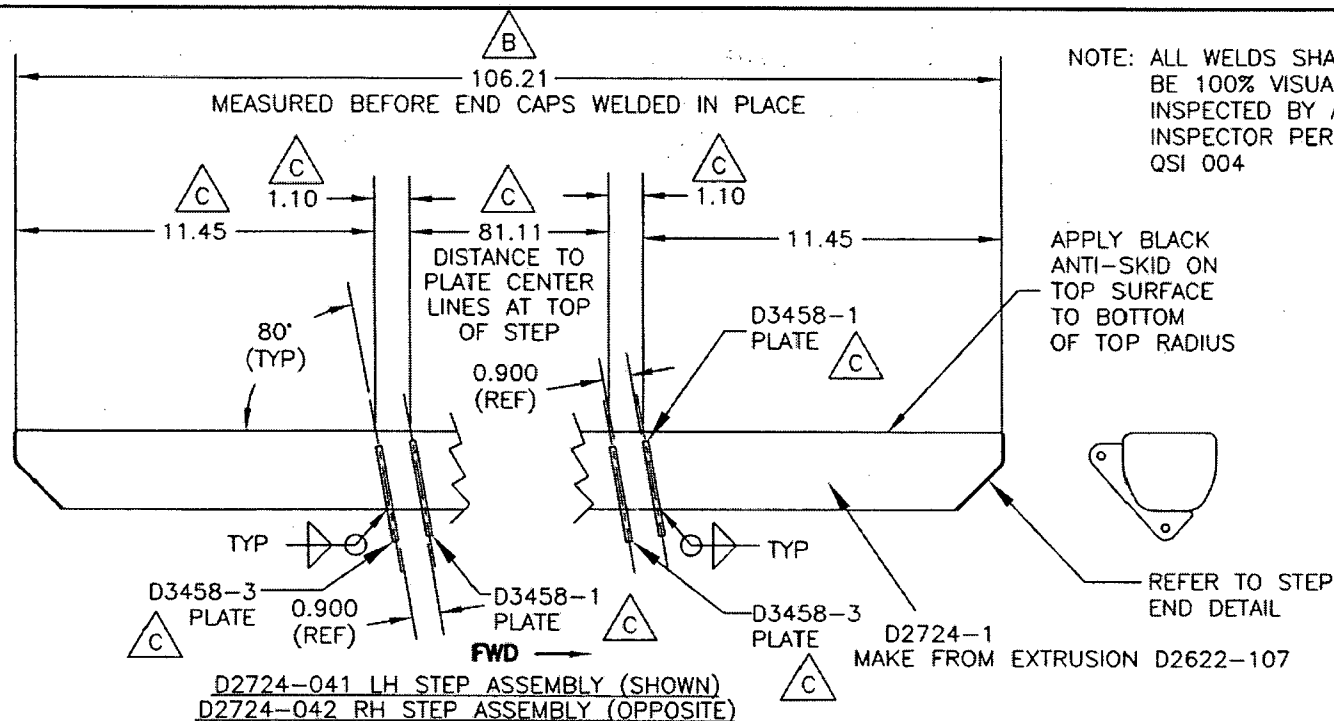
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

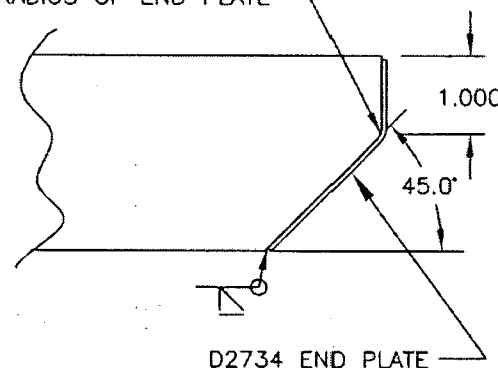
DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
297284
SHOP COPY
RETURN TO
ENGINEERING

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. C
KE	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.19		206L/407 STEP ASSEMBLY	NTS
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	

Date: Friday, 07/09/2007 1:11:06 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628
Job Number	: 34468		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 07/09/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: ECN 1029
First Issue	: N/A	Project Number	: N/A
Previous Run	: 00015	Drawing Revision	: N/A
	Type : LARGE FAB ASSY	Material	: N/A
Written By	:	Due Date	: 14/09/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK - ADD NEW PAPERWORK PER ECN 1029

EASA STC: EASA.IM.R.S.01339 :

D206-628-011

33411 (3X)

33038 (4X)

32979 (1X)

D206-628-012

32980 (1X)

33892 (1X)

D206-628-013

D206-628-014

18533 (1X)

18943 (1X)

D206-628-021

31976 (3X)

33756 (3X)

29739 (1X)

D206-628-021BL

33649 (2X)

D206-628-022

33757 - 31977 (3X)

D206-628-023

33921 (1X)

D206-628-024

33922 (1X)

D206-628-031

31010 (4X)

D206-628-032

29738 (1X)

31011 (4X)

D206-628-033

30806 (2X)

31241 (2X)

D206-628-034

30807 (2X)

7/8/11 SP

Date: Tuesday, 05/02/2008 3:13:02 PM
User: Dominique Dube

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628-032
Job Number	: 37231		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206628032
This Issue	: 05/02/2008 S.O. No. :	Drawing Number	: ECN 1118
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 37221	Material	:
Written By	:	Due Date	: 12/02/2008 Qty: 5 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
PULL FROM STOCK

D206-628-032 CHG002 1x B29738 ✓ 29738 /
4x B31011 ✓ 31011 (4X)

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
ADD NEW PARTS TO KIT PER ECN 1118

*** NEW RED AND WHITE LABELS REQUIRED FOR
NEW CHANGE NUMBER ***

8x D2732 RUBBER EXTRUSION
CUT 3.00" LONG B 24717

4x AN4-13A BOLT B M106815

4x AN4-14A BOLT B M128613

3.0	D2732	Rubber Extrusion
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Comment: Qty: 82.0000 f(s)/Unit Total: 40.0000 f(s)
Rubber Extrusion B 34717

Date: Tuesday, 05/02/2008 3:13:02 PM
User: Dominique Dube

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-628-032

Job Number: 37231

Part Number: D206628032

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

M106815

5.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

M105653

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*** PLEASE ADD A COPY OF THIS WORK ORDER
TO THE ABOVE WORK ORDERS ***

5
D 08/02/26

Job Completion



mini 2008/2/19 8